

A1. 508

Work Order ID 69704

Tuesday, May 17, 2011 12:43:04 PM



Page 1

Item ID: D2809

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 5/18/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-05-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2809

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA204

SA 11/5/25

12 0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SA 11/5/25

12 0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SA 11.5.25

12 0

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Tumble & deburr all sharp edges as per dwg

N/A @ 11.05.25

140

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

12 @ 11-5-25.

150

0.00



White Gloss (Ref: 4.3.5.1) per QSI005 4.3 Alum

Powdercoat

Memo

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A @ 11.05.25

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Cust Item ID:

Required Date: 5/23/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

12 0 11/15/12 5

170



Identify as per dwg & Stock Location 23

0.00

Packaging

Memo

0.00

11/15/12 5

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

11/15/12 5

11/11-05-28
12

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, May 17, 2011 12:43:01 PM

Page 1

Work Order ID: 69704

Parent Item: D2809

Parent Item Name: Bushing



Start Date: 5/18/2011

Required Date: 5/23/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP ☐ C ☐ 02.03.07 ☐ Now turned in house ☐ NG ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R0.500

Purchased

No

100

f

93.5850

0.0995

1.256842



6061-T6 Round Bar .500"



SA 11/5/25

625

SA 11/5/25

Location

MAT012

114488

117379

117481

Loc Qty

93.585

4.605

88.98

Loc Code

1.31 Lt

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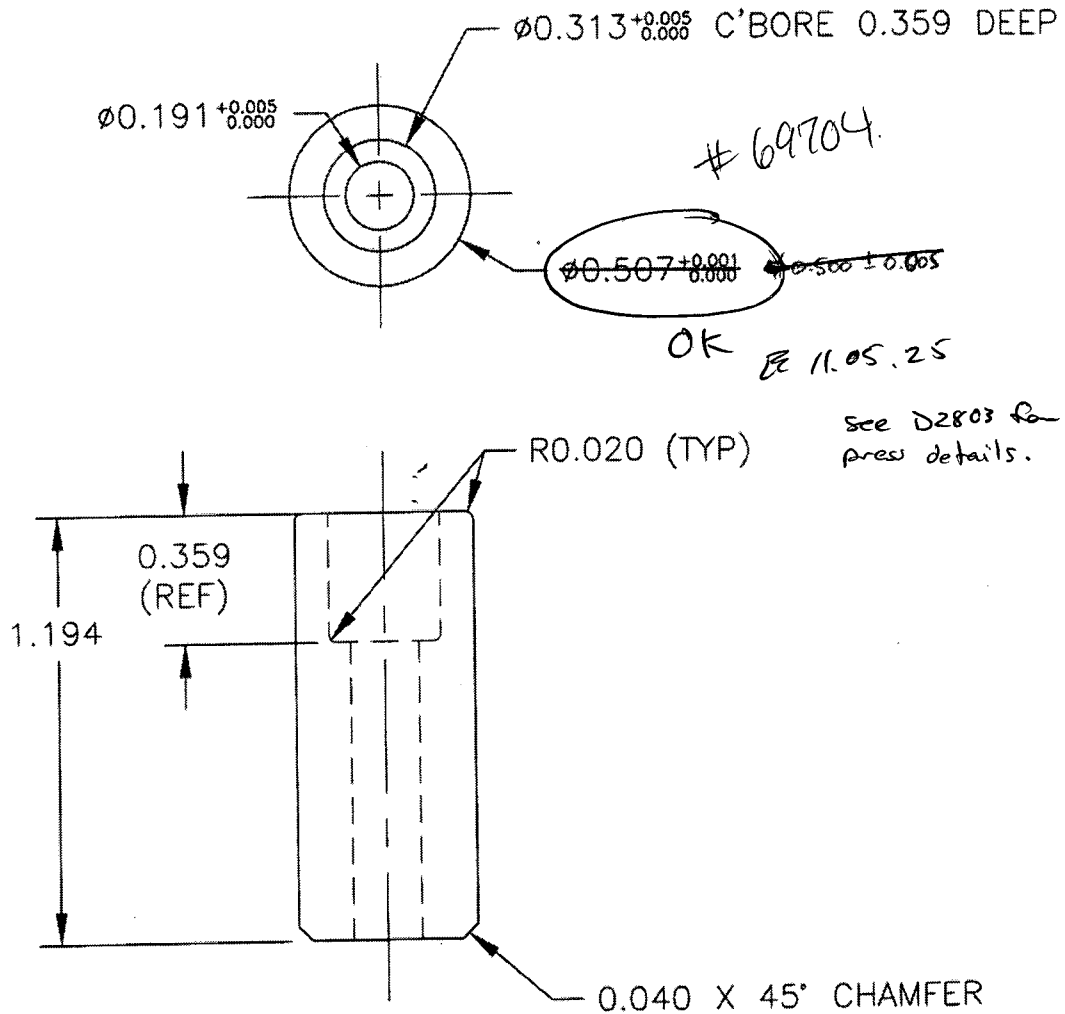
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	# CP 01.04.26	ADD POWDER COAT; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES						
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